

# Work Order ID 54341

March 4, 2010 10:01:35 AM



Item ID: D3772-1

Accept



Setup Start



Revision ID:

Item Name: Back Leg

Stop



Start Date: 12/08/09 Start Qty: 20.00



Cust Item ID:

Required Date: 12/16/09 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3772

Rev A

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 31.500" long

*mk 10/03/10*

*12*

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA787 Rev: *AA* & Dwg D3772 Rev: *A*

*L.S. 10/03/11*

*12*

*1*

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

*L.S. 10/03/11*

*12*

*1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3772-1 PAR #: \_\_\_\_\_ Fault Category: Machined Parts NCR: Yes No DQA: 1 Date: 10/03/29  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1 Date: 10/03/30

NCR: <u>54341</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/03/11</u>	<u>110</u>	<u>all hole are off center by .250"</u> <u>RE. operator took wrong plug for 2" type. We have 3 plug</u> <u>But one have .250" thicker than the others so forget</u> <u>Too retake the origin.</u> <u>R.C. Lack of attention.</u>	<u>[Signature]</u>	<u>replace Batch # 113494</u> <u>Qty 7</u> <u>Incorrect plugs disposed of.</u> <u>Scrap &amp; destroy.</u>	<u>[Signature]</u> <u>10/03/11</u>	<u>amk</u> <u>10/03/15</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>10-03-11</u>
			<u>[Signature]</u>				<u>[Signature]</u>	<u>[Signature]</u> <u>10-03-11</u>

NOTE: Date & initial all entries



# Work Order ID 54341

March 4, 2010 10:01:35 AM



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Item ID: D3772-1

Revision ID:

Item Name: Back Leg

Start Date: 12/08/09 Start Qty: 20.00

Required Date: 12/16/09 Req'd Qty: 20.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

*ink 10/03/15*

*12 0*

140



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

1-cut tube to length as per dwg D3772 2- deburr 3-bend tube as per dwg D3772

*7 m. d*

*(12X)*

*10/03/16*

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*12*

*100317*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54341

March 4, 2010 10:01:35 AM



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Item ID: D3772-1

Revision ID:

Item Name: Back Leg

Start Date: 12/08/09

Start Qty: 20.00

Required Date: 12/16/09

Req'd Qty: 20.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Packaging

Packaging

Identify as per dwg & Stock Location: 254

0.00

Memo

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/11 12

10/03/24

10/03/11 9



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March 4, 2010 10:03:32 AM

Page 1

Work Order ID: 54341

Parent Item: D3772-1

Parent Item Name: Back Leg

Comments: IPP Rev:A 08-06-18 rev.A as per dwg DD verified by:EC  
IPP Rev:B 08-09-24 Now on Haas JLM Verified By:EC

Start Date: 12/08/09

Required Date: 12/16/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR1.250W.125		Purchased	No			110	f	65.7500	39.7674			

304 RD Tube 1.250 x .125w

## Warehouse

### Location

Main Warehouse

MAT

110316

113494

## Loc Qty

65.75

4.5

61.25

f

## Loc Code

0.0000

0.0000

M316TR1.250W.120

Purchased

No

316 RD tubing 1.250 x .120w

33.075 mfr 10/03/10

A.

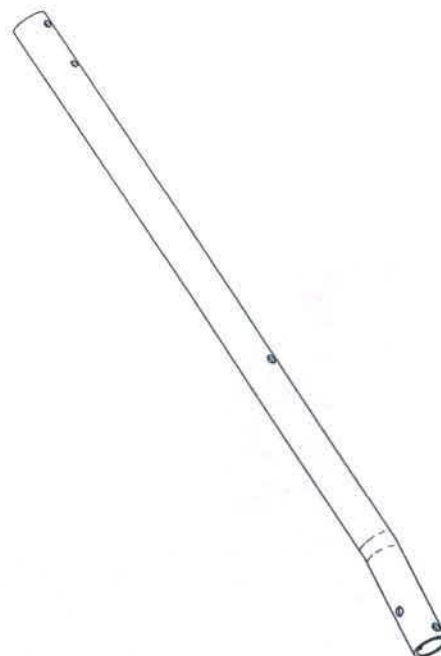
mfr 10-3-24











**D3772-1 BACK LEG**

*1054341*

**RELEASED**  
08-05-12/11/14

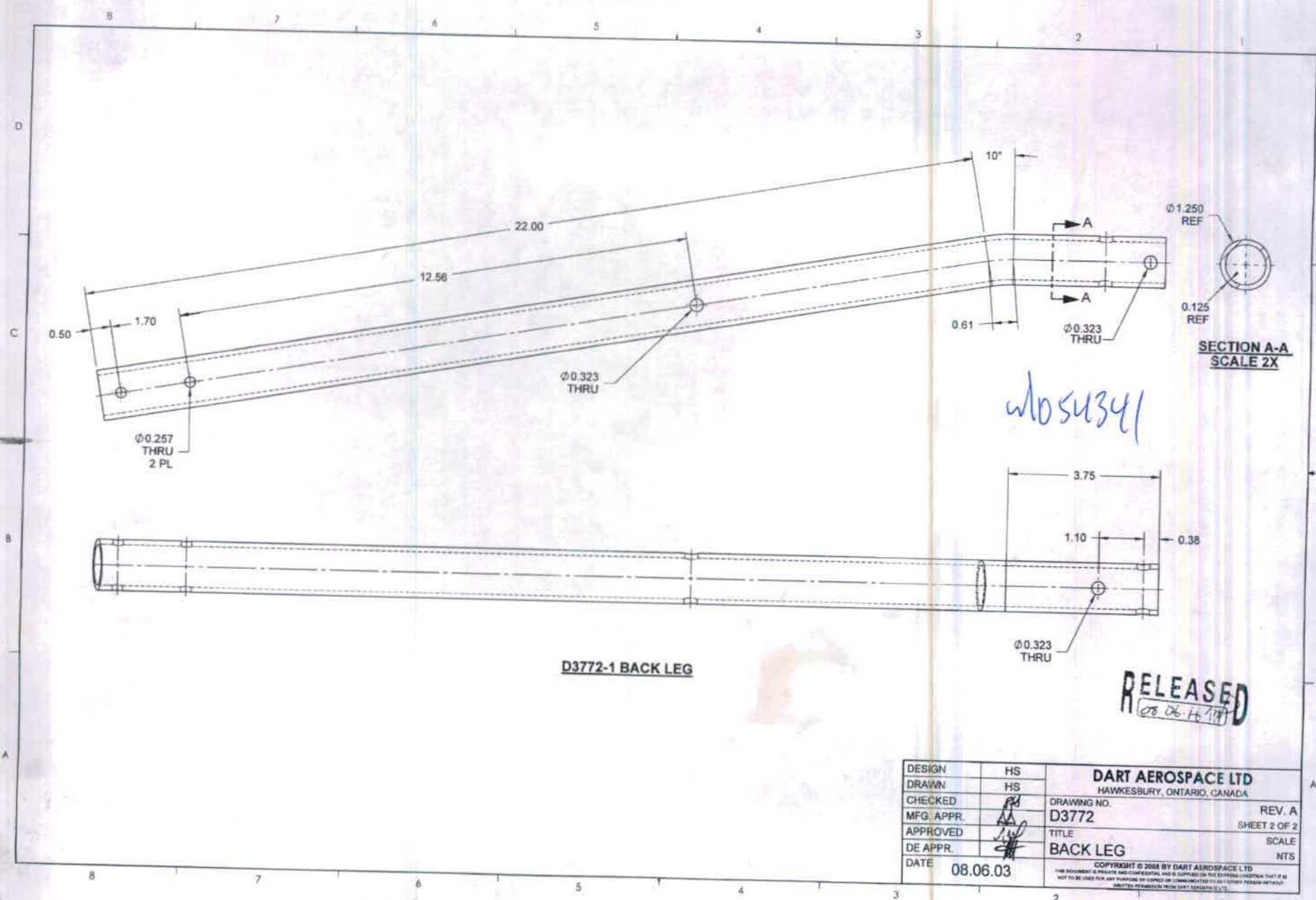
**NOTES:**

- 1) MATERIAL: AISI 304/316 SS TUBING 1.25" OD X 0.125" WALL (REF DART SPEC M304TR1.25W.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.26 lbs

A	NEW ISSUE		HS	08.06.03
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3772</b>  TITLE <b>BACK LEG</b>	REV.	
DRAWN	HS		SHEET 1 OF	
CHECKED	<i>[Signature]</i>		SCALE	
MFG. APPR.	<i>[Signature]</i>		NT	
APPROVED	<i>[Signature]</i>			
DE APPR.	<i>[Signature]</i>			
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DRAWN	HS		
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MFG. APPR.	<i>[Signature]</i>	<b>D3772</b>	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BACK LEG</b>	NTS
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